

Date: Thursday, 24/04/2008 10:11:43 AM
 User: COSS Admin

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	MOUNTING PLATE		
Job Number	38771		Part Number	D3694041		
Estimate Number	13244		Drawing Number	D3694 REVA PRELIM		
P.O. Number			Project Number	N/A		
This Issue	24/04/2008	S.O. No. :	Drawing Revision	A PRELIM 08.04.18		
Prsht Rev.	NC		Material			
First Issue	11		Due Date	01/05/2008	Qty:	2 Um: Each
Previous Run	38474					
Written By	<u>JL</u> 08.04.24					
Checked & Approved By						
Comment	Est Rev.A 08-03-27 new issue DD verified by:JLM					

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE 

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6B1000X12000	6061-T6 Bar 1.0" x 12.0"
Comment: Qty.: 0.6300 f(s)/Unit Total : 1.2600 f(s) 6061-T6 Bar 1.0" x 12.0" Batch: <u>104719</u> HB 8-4-24		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET <u>A</u> <u>A</u> HB 8-4-24 Cut Blank		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1		

1- Mill as per Folio FA731 Rev. A & Dwg D3694 Rev. A

PTO →

2-Deburr per dwg D3694

3-Tap as per Dwg D3694 for 10-32 Helicoils

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/05/03



5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 08.05.13

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: MOUNTING PLATE	
Job Number: 38771	Part Number: D3694041	
Job Number:		
Seq. #: 6.0	Machine Or Operation: HAND FINISHING1	Description: HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT		
8.0	D36943	MOUNTING PLATE ASSY
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) MOUNTING PLATE ASSY Batch: B 38722		
FF	08-05-14	(2)
9.0	MS21209F120	HELI COIL
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) HELI COIL Batch: M107823		
FF	08-05-14	(2)
10.0	MS24693C69	SCREW
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) SCREW Batch: M107737		
FF	08-05-14	(2)
11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Install helicoils as per Dwg D3694		
2-Install plate as per Dwg D3694	FF	08-05-14
12.0	QC5	INSPECT WORK TO CURRENT STEP ENGINEERING APPROVAL
Comment: INSPECT WORK TO CURRENT STEP		
	6.1	Powder coat grey as per dwg. * Do not powder coat in +hreaded holes.
		 08-06-07 P+O

08/09/08 / 6.1 / start time: 8:20 / Temp: 320° / Fd
Finish time: 8:50 / 08/09/08

Date: Thursday, 24/04/2008 10:11:43 AM

User: COSS Admin

Process Sheet

* Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING PLATE

Job Number: 38771

Part Number: D3694041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

N/A

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

0806.04 Prototype

Job Completion



POSITIVE RECALL

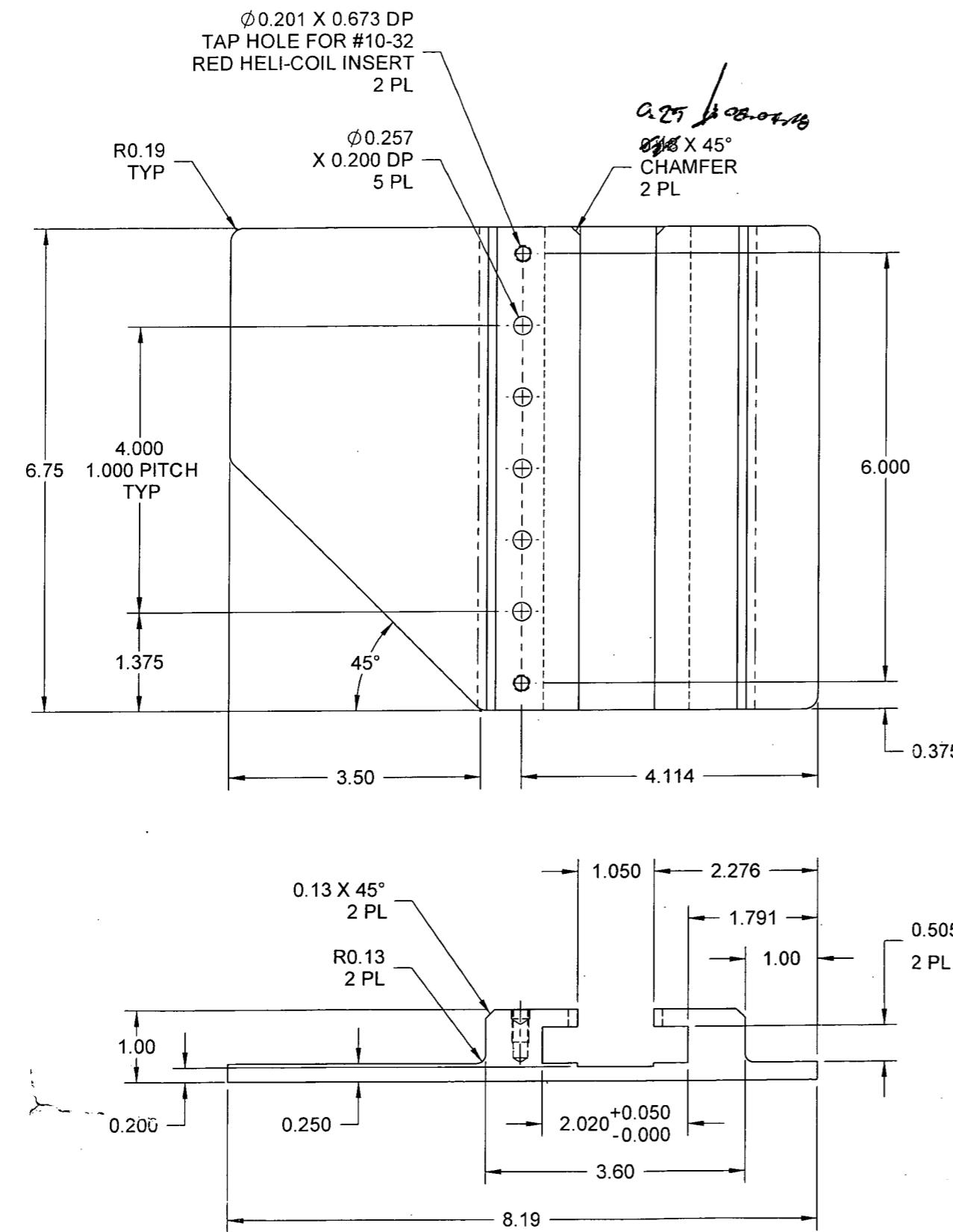
EFFECTIVE 08/04/2008 AUTOMATIC

RELEASED

DATE

Change w/o 0224
mf 08-06-16

8 7 6 5 4 3 2 1



D3694-1 MOUNTING PLATE

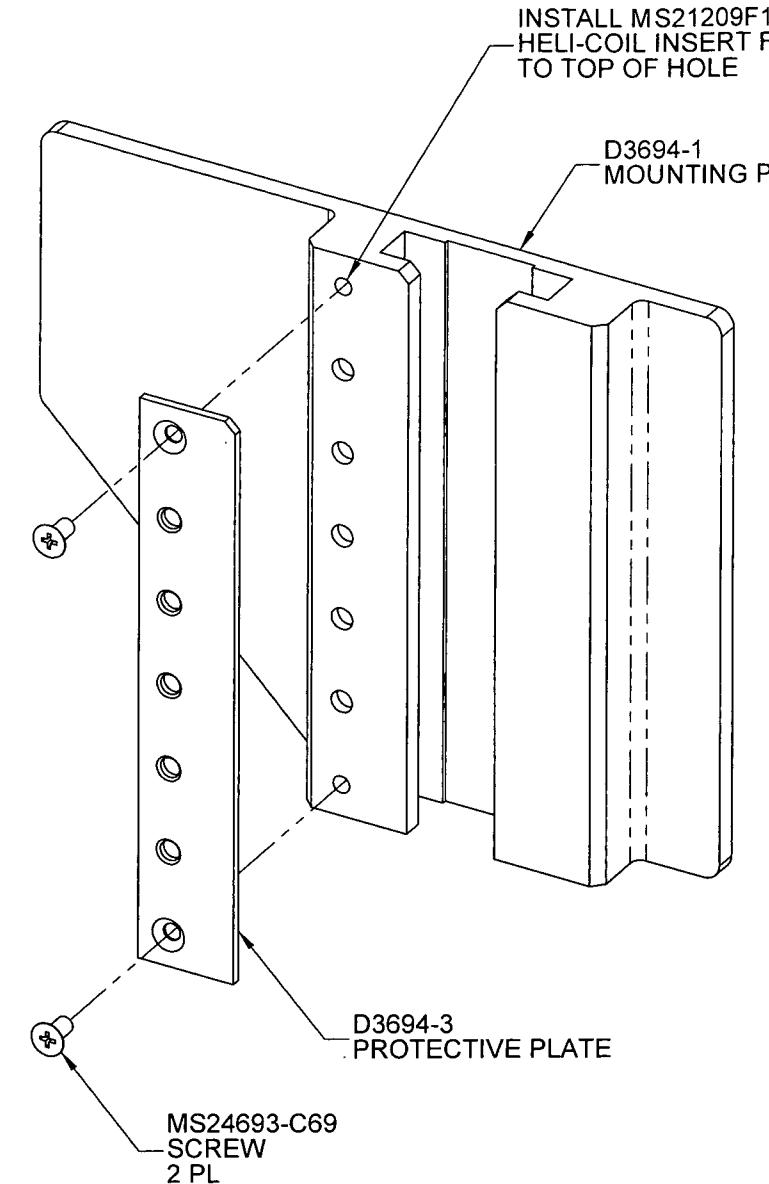
1/13
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
PRELIMINARY ISSUE
A 08.03.14

D3694-1 NOTES:

- MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: N/A
- WEIGHT: 2.14 lbs

DESIGN	<i>1A</i>	DART AEROSPACE LTD	
DRAWN	<i>1A</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>1</i>	DRAWING NO.	
MFG. APPR.	<i>1</i>	D3694	
APPROVED	<i>1</i>	REV. A	
DE APPR.	<i>1</i>	SHEET 2 OF 3	
DATE	08.03.14	TITLE	
		SCALE	
		NTS	
		MOUNTING PLATE ASSY	
		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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		NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	
		WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -041	P/N	DESCRIPTION
X	D3694-041	MOUNTING PLATE ASSY
1	D3694-1	MOUNTING PLATE
1	D3694-3	PROTECTIVE PLATE
2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
2	MS24693-C69	SCREW



D3694-041 MOUNTING PLATE ASSY

D3694-041 NOTES:

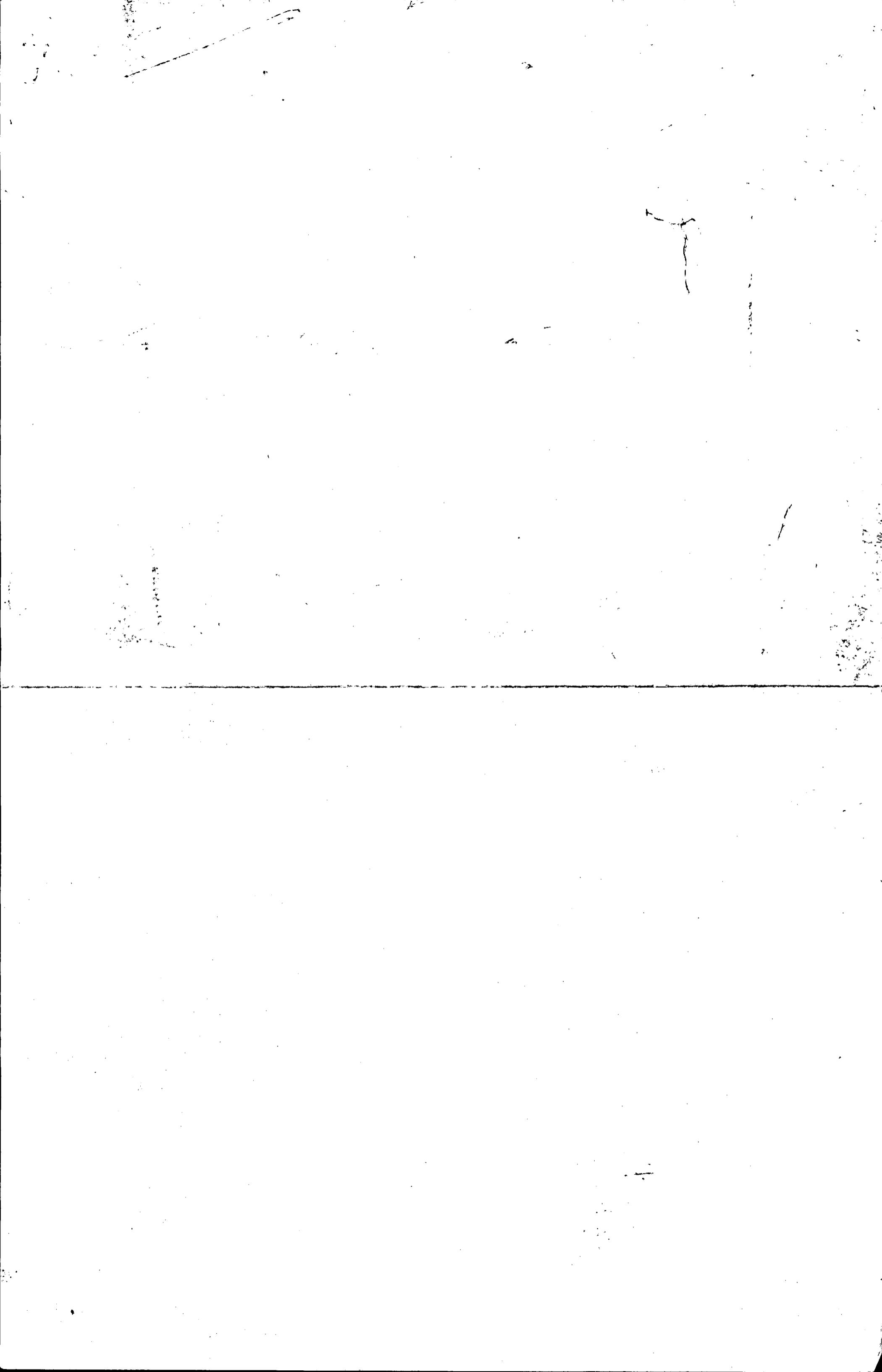
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.36 lbs

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

PRELIMINARY ISSUE

08.04.17

A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED		DRAWING NO.	
MFG. APPR.		D3694	REV. A
APPROVED		TITLE	SHEET 1 OF 3
DE APPR.		MOUNTING PLATE ASSY	NTS
DATE	08.03.14	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DART AEROSPACE LTD	Work Order:	58771
Description: Mounting plate	Part Number:	3695-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.75	$\pm .030$	6.751	/			
1.375		1.374	/			
1.000 pitch		1.000	/			
3.50	$\pm .030$	3.50	/			
4.114	$\pm .010$	4.113	/			
.375	$\pm .010$.375	/			
6.000	$\pm .010$	6.000	/			
.25x45°	$\pm .030$.25x45°	/			
$\phi 2.01 \times 6.73$ ap	$\pm .006$ $\pm .001$	$\phi 2.02 \times 6.75$	/			
$\phi .257$	$\pm .006$ $\pm .001$	$\phi .257$	/			
.200 dep		.200	/			
1.00	$\pm .030$.971	/			
.200	$\pm .010$.198	/			
.250	$\pm .010$.245	/			
8.19	$\pm .030$	8.189	/			
3.60	$\pm .030$	3.604	/			
2.020	$\pm .050$ $\pm .000$	2.025	/			
.505	$\pm .002$ $\pm .005$.503	/			
1.00	$\pm .030$	1.062	/			
1.791	$\pm .016$	1.794	/			
2.276	$\pm .010$	2.279	/			

Measured by: 	Audited by: 	Prototype Approval: 
Date: 08/05/03	Date: 08/05/03	Date: 08/05/03

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	
Description:	Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article | Prototype

Measured by:	<u>SD</u>	Audited by:	<u>SA</u>	Prototype Approval:	<u> </u>
Date:	08/05/03	Date:	09/06/03	Date:	06.06.03

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Date: Thursday, 24/04/2008 10:11:43 AM
 User: COSS Admin

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	MOUNTING PLATE
Job Number	38771	Part Number	D3694041
Estimate Number	13244	Drawing Number	D3694 REVA PRELIM
P.O. Number		Project Number	N/A
This Issue	24/04/2008	Drawing Revision	A PRELIM
Prsht Rev.	NC	Material	
First Issue	/ /	Due Date	01/05/2008
Previous Run	38474	Qty:	2
Written By	<i>JM 08-04-24</i>	Um:	Each
Checked & Approved By			
Comment	Est Rev.A 08-03-27 new issue DD verified by:JLM		

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE



Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0 M6061T6B1000X12000 6061-T6 Bar 1.0" x 12.0"



COPPER + Brass
R/O : 3300



Comment: Qty.: 0.6300 f(s)/Unit Total : 1.2600 f(s)

6061-T6 Bar 1.0" x 12.0"

Batch: *104719**H3 8-4-34*

2.0 WATER JET

FLOW WATER JET

Comment: FLOW WATER JET
Cut Blank

A
A

H3 8-4-34

3.0 HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA731 Rev: A & Dwg D3694 Rev: A

P10

2-Deburr per dwg D3694

3-Tap as per Dwg D3694 for 10-32 Helicoils

*68/03/03*

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*08/05/03*

QC3

SECOND CHECK



QC4 CHECK

Date: 7/01/13Batch No: M104719Supplier: COPPER BRASSDart P/O: 3300

Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr

Release Note Attached: Yes No N/A
 Waybill Attached: Yes No
 Shipment Complete: Yes No N/A
 QC8 Inspection EC-070613 N/A
 Work Order N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 JL

Production/Admin:

Date 07/01/14Received/Costing KPL 4845Initial LJLocation

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

OUR NEW OFFICE HOURS
 7:30 AM TO 5:00 PM - MONDAY TO FRIDAY
 *** CUSTOMER PICK-UP HOURS ***
 *** 9:00 AM TO 4:00 PM ***
 PLEASE NOTE OUR NEW GST #: 140223934
 EFFECTIVE MARCH 20, 2006

ALUMINUM • BRASS • COPPER • PLASTIC • STAINLESS

Material	Processing	Freight	Other	Taxes	TOTAL DUE
483.84				29.03	512.87

Taxes: GST/SAL	29.03	0.00
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GST# R140223934



ALCOA EXTRUSIONS, INC.
MORRIS OPERATIONS
8920 NORTH TAYLOR ROAD
MORRIS, IL
60450-0913

Alcos Extrusions, Inc. a subsidiary of Alcon Inc.

Invoice To Customer

THYSSENKRUPP MATERIALS NA INC
2821 LANGSTAFF ROAD
ATTN: ACCOUNT PAYABLE

CONCORD, ON - L4K-1A1
Ship To Customer

THYSSENKRUPP MATERIALS NA INC
2821 LANGSTAFF ROAD

CONCORD, ON - LAKSC6

Certified Inspection Report

Sales Order Number 4606389	Line No. 10	Customer P/O PEC-66256-8
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Cert Number	Page
AEP1197325	1 of 1
Cert Creation Date	Cert Print Date
10-MAY-07	10-MAY-07

Quantity Shipped	Date Shipped
1506	10-MAY-07
B/L	Item No.
1233111	G03270577
Delivery ID	Item No. Rev
2236571	-
Customer Part No	
505054	

Item Description

Extruded Econ-o-Plate
1.000 TK x 12.000 W
SECT 505054
144.5 IN LN
6061/T6511
EN M-MILL
W/H 14.112 H 2 CS 12.1
Marking SHOT MARKED;
ASTM B221 REV 06
AMS-QQ-S-2000 REV
ASME SB221 REV
UNS#A96061 REV

[Legal Statement](#)

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material meet the composition and had the mechanical properties shown on the face of this certification. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. This certification is not to be reproduced in part or form without prior written approval of our Quality Assurance Dept.

Signature And Title

Juan L. Arciniega
Quality Assurance Manager

10-MAY-07

Quantities per Lot / Packages

Package Number	Lot Number	Quantity	UOM	Weight	
				Gross	Net
GHI-KGH126238	7228715	6	PCS	1044	1014
GHI-PKG126239	7228713	3	PCS	522	492

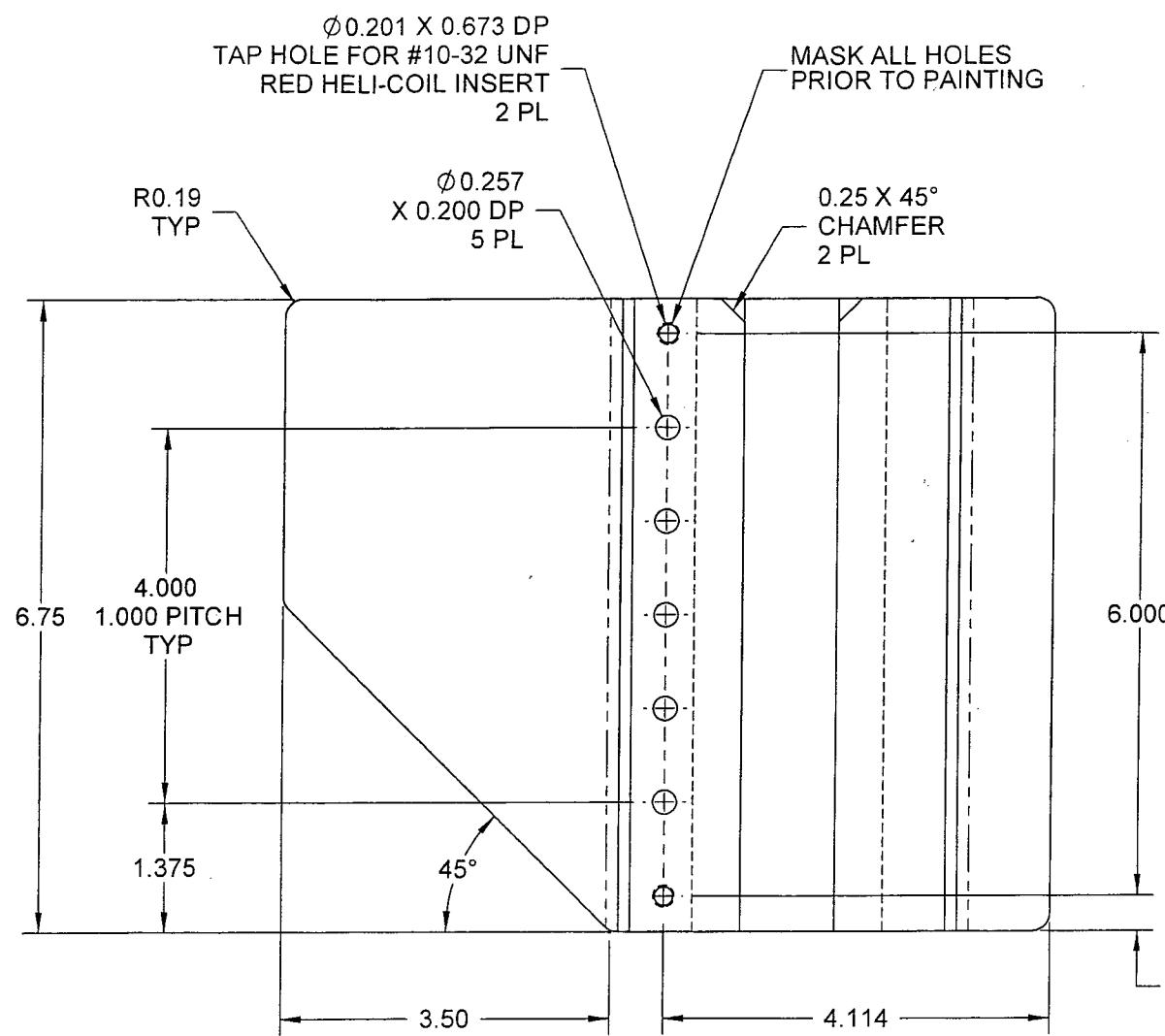
Mechanical Properties - Test Results

Test Type		UTS - L	TYS - L		EL 4D-Long	
UOM		KSI	KSI		PCT	
# of Tests		-	-		-	
Test Temper	Lot Number	# of Tests	Min	Max	Min	Max
T6511	7228715	2	41.7	43.4	36.5	37.3

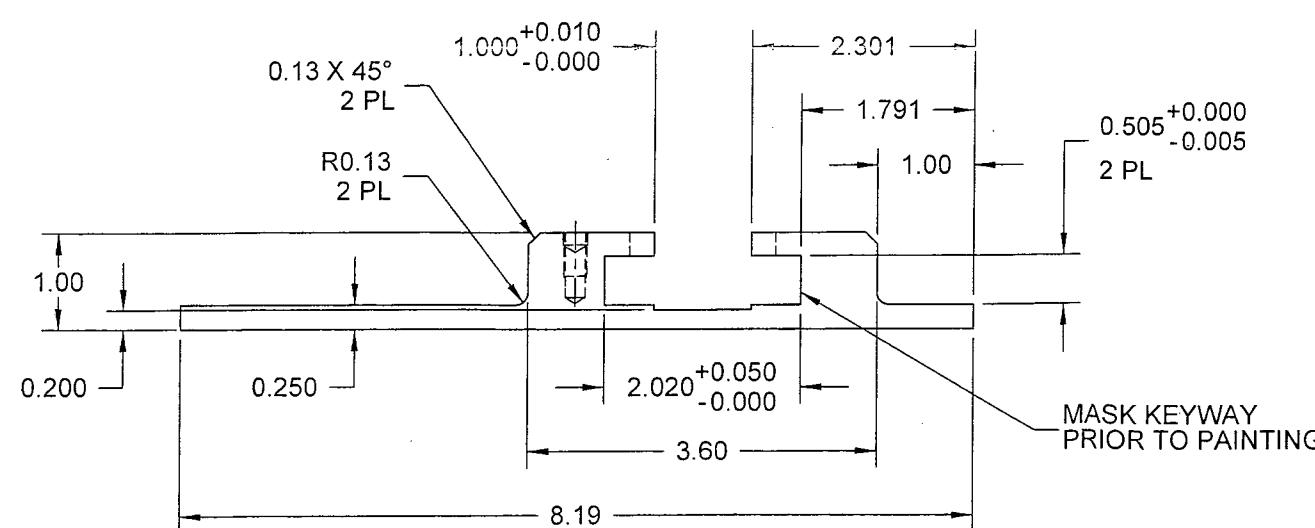
Cat Notes

Made in USA

8 7 6 5 4 3 2 1 .



D3694-1 MOUNTING PLATE



PRELIMINARY ISSUE

D3694-1 NOTES:

DESCRIPTION:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.15 "

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3694	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	
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